PROCEDURE FOR THE VERIFICATION OF CRITICAL DIMENSIONS OF CUBE MOLDS ASTM C 109

A. PURPOSE

The purpose of this procedure is to verify the critical dimensions of cube molds. This verification is made annually (see note). ASTM requires a calibration every 30 months.

B. APPARATUS REQUIRED

- 1. Straight edge.
- 2. Calibrated calipers.
- 3. 12 inch steel ruler.
- 4. Square.

C. PROCEDURE

- 1. Follow Table 1 of ASTM C 109 to verify the planeness of sides, the distance between opposite sides, the height of each compartment, and the angle between adjacent faces.
- 2. Tamper
 - a. Observe that the tamper is in good condition and made of suitable material.
 - b. Measure the length and width of the measure.
 - c. Check the planeness of the tamper face.
 - d. Verify that the tamper face is at right angles to tamper shaft or length.

D. TOLERANCES

All tolerances are as listed in ASTM C 109, Table 1.

Note: CCRL inspection shall be the verification of record.

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EQUIPMENT VERIFICATION RECORD

Verified By:	Date:				
Equipment: Cube Mold	Location (Lab):				
Identification No.:	Verification Frequency: 12 months				
Previous Verification Date:	Next Due Date:				
Verification Equipment Used: Straight edge, SN:	Calibrated calipers, SN:				
12 in. Steel Ruler, SN: Carpenter's square, SN:					
Verification Procedure: (In-house) OMR-CVP-43 / ASTM	C 109				
2 INCH CUBE MOLDS New Used					
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Planeness of sides < 0.001 in. <0.002 in. (0.025 mm)(0.05 mm)

Distance between opposite sides 1.995 - 2.005 in. 1.98 - 2.20 in. (49.87 - 50.13 mm)(49.75 - 50.75 mm)

Height of each component 1.995 - 2.01 in. 1.985 - 2.01

(49.87 – 50.25 mm) (49.62 - 50.25 mm)

Angle between faces		85 – 90°		85 - 95°		
Mold Number		eness Side 2	Distance Between Sides	Height	Angle	Mold Condition

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